

Date: Thursday, 01/05/2008 9:45:52 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 38920		
Estimate Number	: 10530		
P.O. Number	:	Part Number	: D2571
This Issue	: 01/05/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2571 REV E
First Issue	: / /	Project Number	: N/A
Previous Run	: 38653	Drawing Revision	: E
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 10/05/2008
Checked & Approved By	: <u>JLD 08.5.01</u>	Qty:	8 Um: Each
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: B34875

SB 08/05/09

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. SB Double check by: J.L

Plb

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

SB 08/05/09

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2571 & D2572

SB 08/05/13

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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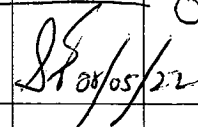

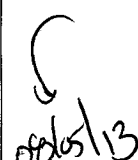
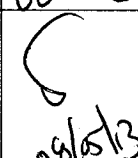
Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SB 08/05/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: 1 Date: 08/05/22
 QA: N/C Closed: 1 Date: 08/05/22

NCR: 38920		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/5/22	# 2.3	During 3rd operation the SADDLE pulled up and caused the SADDLE to twist. ^{appropriately} 0.100" on the Base of the slid tube.	 08/05/22	Adjust speed to compensate for the 1" size end mill	 08/05/22	J.L. 08/05/22		
		R.C. no slow a speed for a aggressive end mill		Scrap and Destroy and Replace Qty (x1) P# <u>B34875</u>			08/05/22	
				install note in photo for what speed 355 end mill Be to be done at 08/05/22				

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 38920

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/05/14

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

920 / 15

08-05-20

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:15

OVEN TEMPERATURE:

220 °F

FINISH TIME:

11:45

M-1

08/05/20

(8X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD

08/05/20

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57432

08/05/21 (P)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/22

Job Completion



MF 08-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 38920
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.443	0.443	.441	.441		
B	1.745	1.755		1.749	1.750	1.750	1.750		
C	3.495	3.505		3.499	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.002	8.002	8.002		
F	0.490	0.510		0.504	0.505	.500	.505		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.503	0.508	0.505	0.503		
J	1.174	1.184		1.179	1.179	1.179	1.178		
K	0.558	0.578		0.570	0.573	0.575	0.572		
L	1.174	1.184		1.179	1.179	1.180	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.494		
N	2.495	2.505		2.500	2.500	2.500	2.499		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.123	0.123	0.124	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.248	0.248	0.248	0.249		
S	0.115	0.135		0.123	0.121	0.121	0.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.958		
V	0.230	0.250		0.232	0.231	0.232	0.232		
W	0.115	0.135		0.118	0.122	0.119	0.119		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		0.365	0.366	.366	.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.629	0.626	0.625		
AC	0.053	0.073		0.0625	0.0625	0.0625	.062		
AD	0.240	0.260		0.243	0.243	0.243	0.243		
AE	1.375	1.395		1.388	1.3905	1.3905	1.3895		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.242	0.247	0.2475	0.247		
AI	2.000	2.020		2.0035	2.008	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: DJP
Date: 08/05/10

Audited by: JL
Date: 08/05/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 38920
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

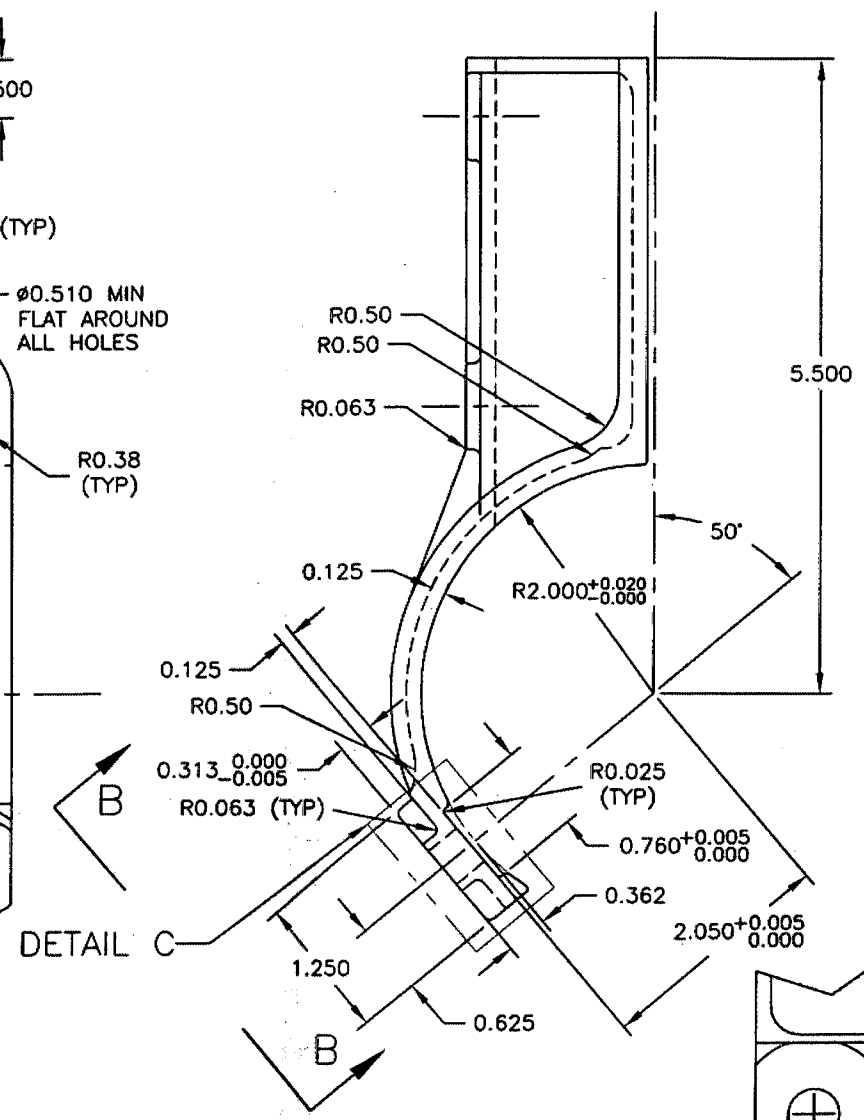
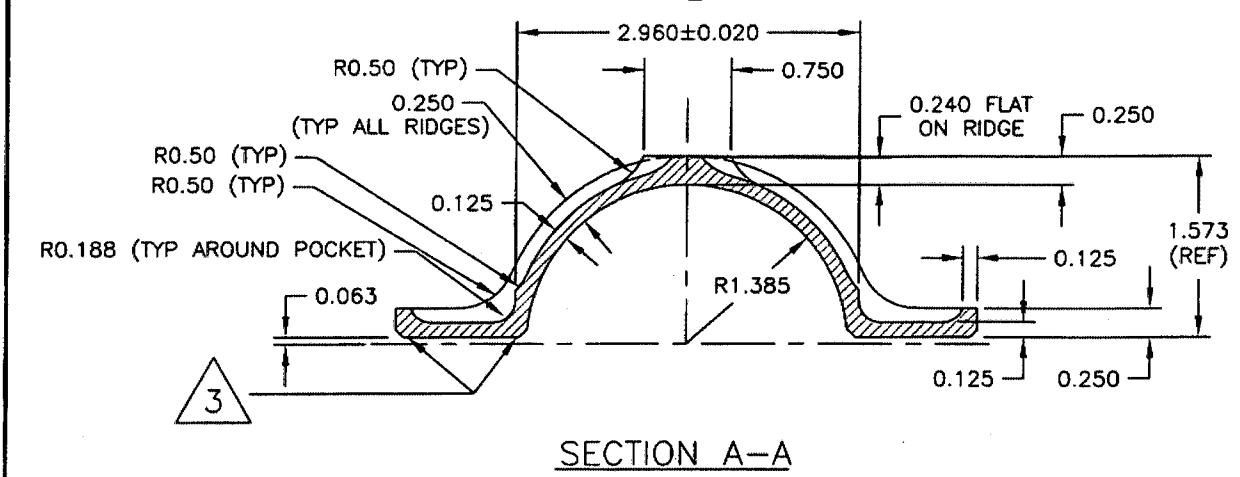
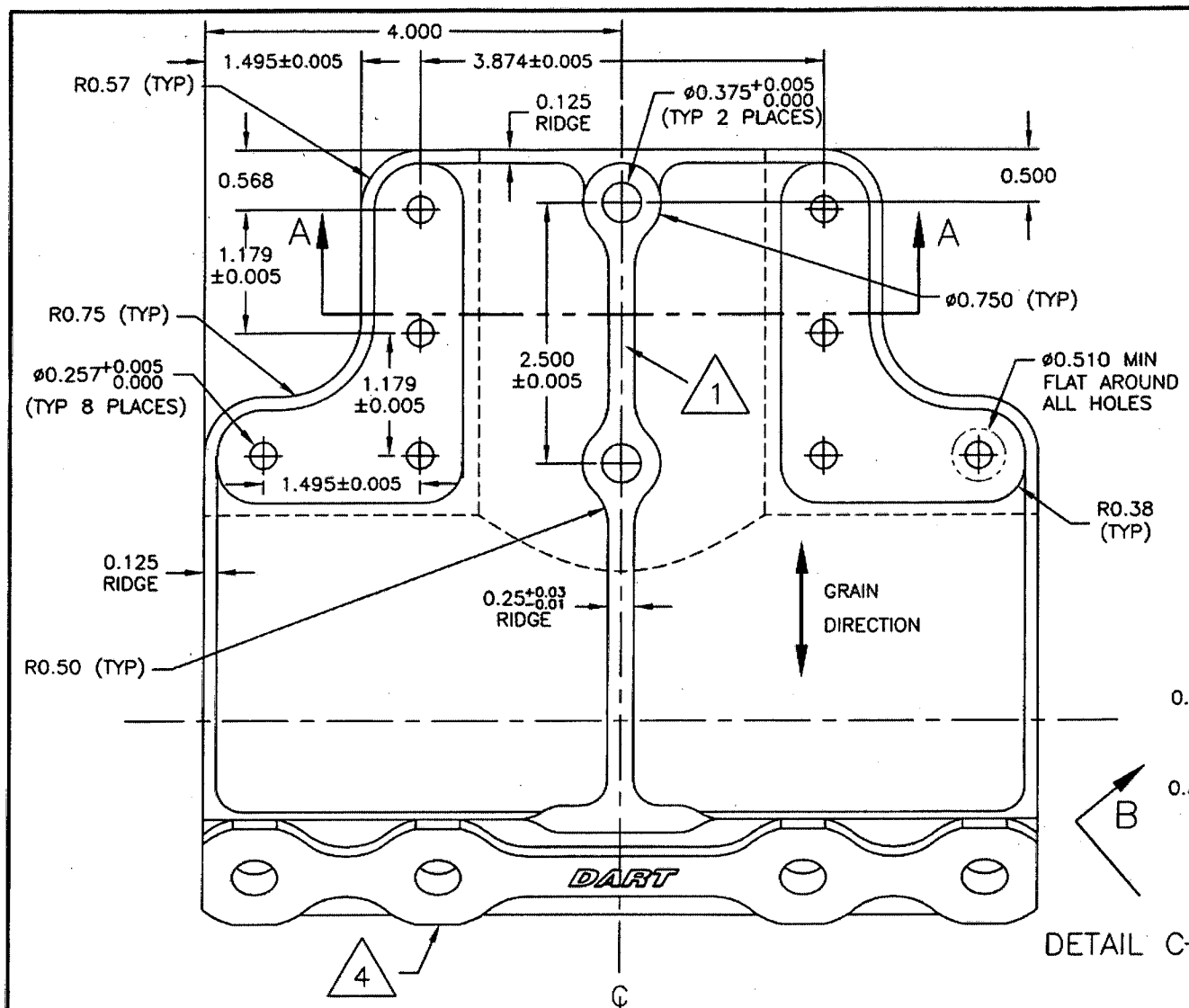
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.7500	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.002	8.001		
F	0.490	0.510		.505	.502	.505	.505		
G	0.257	0.262		0.259	0.259	.258	.259		
H	0.375	0.380		0.378	0.378	.376	.377		
I	0.490	0.510		.505	.505	.500	.500		
J	1.174	1.184		1.179	1.177	1.177	1.179		
K	0.558	0.578		.568	.568	.568	.570		
L	1.174	1.184		1.178	1.178	1.179	1.179		
M	1.490	1.500		1.496	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.499	2.500	2.500		
O	3.869	3.879		3.877	3.874	3.874	3.874		
P	0.115	0.135		0.123	0.12	.122	.122		
Q	0.115	0.135		0.135	0.135	.135	.135		
R	0.240	0.260		0.248	0.248	.248	.248		
S	0.115	0.135		.125	.125	.125	.122		
T	0.178	0.198		0.188	0.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		.233	.240	.236	.237		
W	0.115	0.135		.120	.120	.120	.121		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.361	.367	.361		
AA	0.470	0.530		0.500	0.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.620		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.389		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		0.260	0.260	.260	.260		
AH	0.240	0.260		.250	.250	.245	.245		
AI	2.000	2.020		2.002	2.002	2.000	2.002		
AJ	0.023	0.043		.033	.033	.033	.		
Accept/Reject									

Measured by:	DTP
Date:	08/05/12

Audited by:	J.L
Date:	08/05/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

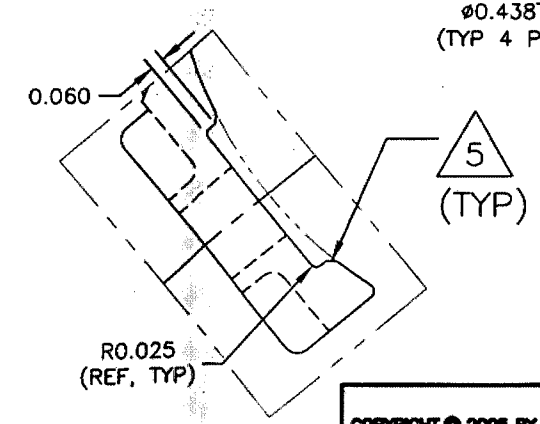
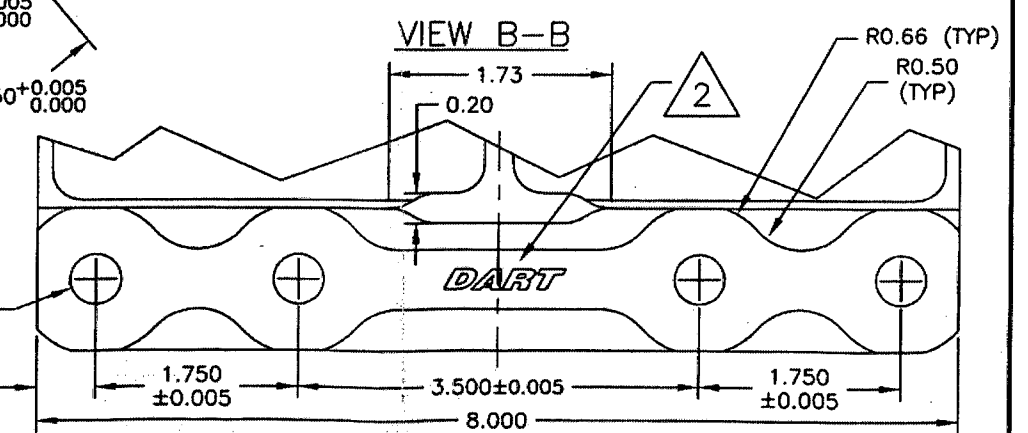
RELEASED
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 - 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
 - 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
 - 4 CHAMFER 0.063" x 45° ALL AROUND
 - 5 CHAMFER 0.033" x 45° (SEE DETAIL C)
- SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 38920



DETAIL C
SCALE 4:3

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	TITLE
		OUTER FWD SADDLE
		SCALE 2:3

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2571
REV. E
SHEET 1 OF 1

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